Vork Order ID 107218 eptember-23-13 11:35:43 AM							Page 1				
Item ID: Revision ID: Item Name:	646.3811 Radius Block		A	ccept	*N900	<b>040</b>	100	)* s	etup Sta	I VI	S1* S2*
	9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:	D:				, i d	17
Approvals:		•	Date: \\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \	Tooling: SPC (Y/N):		te:		R	tun Sta Sto	I/I	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr							-		
646.3800	N/C										
*110 *110* HAAS I		HAAS CNC VERTICAL	. MACHINING #1	0.00					Ø		/13/09/25
HAAS CNC vertica	I machine #1	1-Machine p DWG REV:									
		2- deburr an	nd break all sharp edges								
120		QC2- Inspect parts off m	nachine FAI/FAIB	0.00							
*120*								/	Ø		/13/09/25
QC		Memo		0.00				······································			///

Quality Control

										DQA:	Dat	e:
NCR: Y	es / No				WORK ORDER NON-C	CON	FORN	ANCE / UPE	DATE		····	
										QA Closed:	Dat	e:
Work Orde	r:				DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube		Water Jet	~ ~ ~
Part N	lo	<del></del>	<del></del>		Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Work Order Update	}		noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root		]		Descri	ption of work order update	ln	itial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance		ef Eng		iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator [						1						
Material [						1						
Setup												
Other [												
Process		1										
Supplier												
Training												
Unapproved						İ						
					F	AULT	CATE	GORY				
Landir	ng Gear				General					_	_	
	Bending				Bend		Grain			Ovalized	ĺ	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	H	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct [	Weld
	Crushed/	Crimped			Burrs		nstruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	-	
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misreac	l		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset			_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107218 September-23-13 11:35:43 AM				*107					Page 2		
tem ID: Revision ID:	646.3811			Accept	*N900	<b>040</b>	100	)* s	etup Sta Sto	IA	S1*
Item Name:	Radius Block	G G	404						510	<sup>р</sup> *N	S2*
Start Date: Required Date: Reference:	9/23/13 9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:	_	R	tun Sta	1/7	R1*
			Date:	SPC (Y/N):	D:	ate:			Sto	<sup>p</sup> *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		QC8- Inspect parts - second	d check	0.00				0			
*130* QC Quality Control		Memo		0.00				6_			¥ 13-9-21
140		Outsource process-Anodize	e per QSI017 4.1.10.1	0.00			م م		, ,		
*140* Outsource4 Outsource process -	Anodize	<b>Memo</b> Issue P/O to A	atg: <u>21510</u>	0.00		-	CL	_13	10912	27 (	6)
			dize as per Dwg 646.3								
			PER DWG, SEE NO								
			of Comformity is requ								
150		Receive & Inspect for Dan	nage & Mat'l Certs	0.00				/	///		(
*150* Packaging		Memo		0.00				12	/3/14	22	ري)

Packaging

							٠				DQ.	A:	Date:	
NCR: Y	/es	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UP	DATE			-	. 0
		•							•		QA Close	d:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMEN	IT/PROCE	SS	
Work Orac		<del>-</del>				Rework	7		Skid-tube	Crosstube	1	Wate	er Jet	Engineering
Part N	No.					Scrap	1	l :	Machining	Small Fab	P	rod. Eng. (		Quality
	•					Use-as-is	1	1	noforming	Finishing	4	tore/Packa		Other
NCR N	No.					Work Order Update	1		Large Fab	Composite			plier	
											_			
Root					Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verifi	ication	QC Inspector
Doc/Data														
Equip/Tooling	$\square$													
Operator							İ							
Material														
Setup													ļ	
Other														
Process														
Supplier	П		1											
Training														
Unapproved														
							AU	LT CATE	GORY					
Landi	ng G	Gear				General		_			_			
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Und	er toleranc	:e 🗖	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 107218 September-23-13 11:35:43 AM			*107218*								Page 3
Item ID: Revision ID: Item Name:	646.3811 Radius Block		/	Accept	*N900	<b>040</b>	100	)* 5	Setup Sta	IV	S1* S2*
Start Date: Required Date: Reference:	9/23/13 : 9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:				1.0	17
Approvals:		nn:	Date:	Tooling: SPC (Y/N):		ate:		j	Run Sta Sto	<b>''   \</b>	IR1* IR2*
Sequence ID/ Work Center II 155 *155* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours  0.00 DAS  27 9-89	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*180 *180* Packaging Packaging		Memo	ock Location: 57535	0.00	AND REV***			6x	DAS 28 9-89	3 <u>13-10</u>	0 <i>-2</i> 2
190		QC21- Final Inspection	- Work Order Release	0.00				,	Λ 6		

0.00

Memo

\*190\*

Quality Control

Jet / Rm 13/10/23.

											UQA:	Date.	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	ANCE / UP	DATE	0.4.61	<b></b>	*
						<u> </u>					QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	•					Rework	7	1	Skid-tube	Crosstube	1	Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	i	noforming	Finishing	4	re/Packaging	Other
NCR	No.					Work Order Update	1	6	Large Fab	Composite	1	Supplier	1 1111
				·····			_			,		''	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator			İ										
Material													
Setup													
Other	П												
Process													
Supplier												İ	
Training													
Unapproved													
						F	AUI	LT CATE	GORY				
Land	ing (	Gear				General		=			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			L	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	L	Crushed,	'Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			L	Contamination		Mainte	nance		Part Moved		
		Heat Tre	at			Countersink		Mislabe	led		Positioned \	Wrong	_
1		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

September-23-13 11:35:42 AM

Page 1/

Work Order ID:

107218

Parent Item:

646.3811

Parent Item Name:

Radius Block

**Start Date:** 9/23/13

Required Date: 9/23/13

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.000X00.250	)	Purchased	No				f	6.5320		0.8842104	4		
7075-T6 BAR 1,000' X 0.	250"												

 Location
 Loc Oty
 Loc Code

 MAT
 6.532

 125585
 6.532

1,562 /13/09/25

										DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-O	ONFOR	MANCE / UP	DATE			•
									•	QA Closed:	Date:	
Work Orde	ar:					DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS	,
Part N	- . No.					Rework Scrap Use-as-is	Ther	Skid-tube Machining moforming	Crosstube Small Fab Finishing	i	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	۷o. ِ	<del></del>				Work Order Update	J	Large Fab	Composite		Supplier	J
Root					Descri	tion of work order update	Initial	Ac	ction	Sign &	"	
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						F	AULT CAT	EGORY				
Landi	_	Gear Bending				General Bend	Grain			Ovalized		Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw	are		Ovanzeu Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order: 107218
Description:	Part Number:
Inspection Dwg: Rev:	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

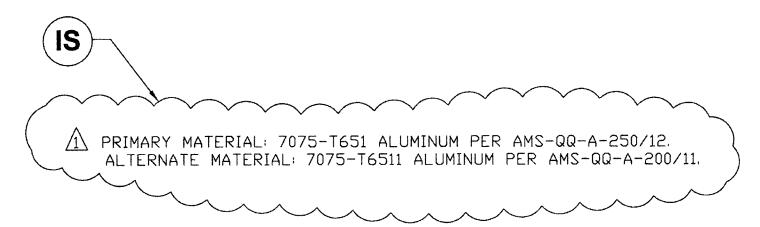
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3,00	= 0,010	3,003	/		1111-04	illan
0,81	+ 0,010	0,808	/		( ) (	/ 7 1
0,19	+ 0,010	0,188	/		, , ,	111
0, 81 0, 19 R 0, 19	+ 0,010 + 0,010 + 0,010 + 0,010	0,188	/			Ladino gange
						-

Measured by:	Just	Audited by:	JL	Preliminary Approval:	
Date:	13/09/25	Date:	13-9-25	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

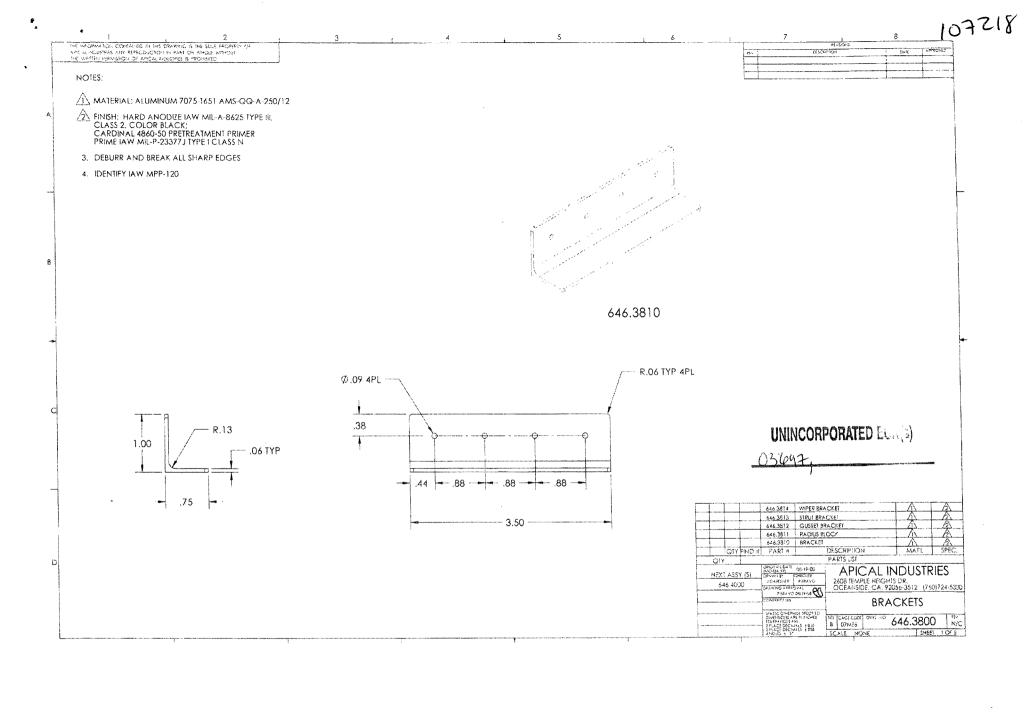
SHEET 1 OF 1 ENGINEERING CHANGE NOTICE NO. 03697 REV: N/C PREPARED B. PETERS EFFECT ON DWG DWG NO. 646.3800 DATE: 11/14/12 ☐ INC. ☒ UNINC. DWG TITLE: BRACKETS INDUSTRIES, INC. MFG David Borber EFFI NEXT ORDER APPROVED BY TRANSACTION CODES (TC)
A-ADD C-CREATE ECR: REASON: D-12-006 ADDED ALTERNATE MATERIAL. D-DELETE R-REVISE

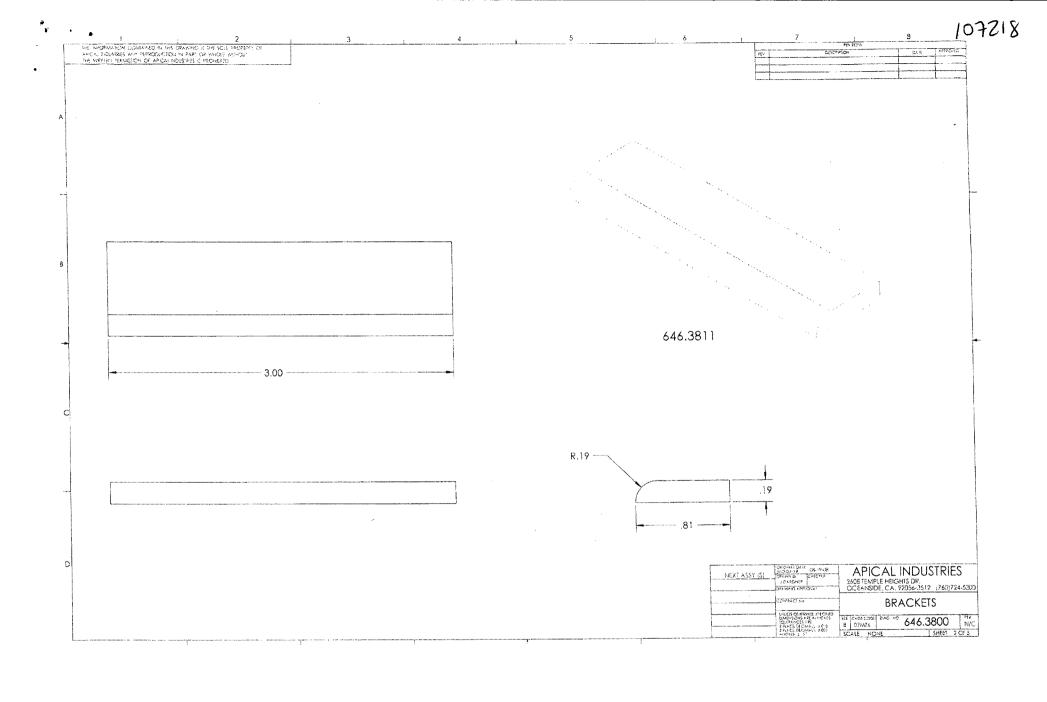


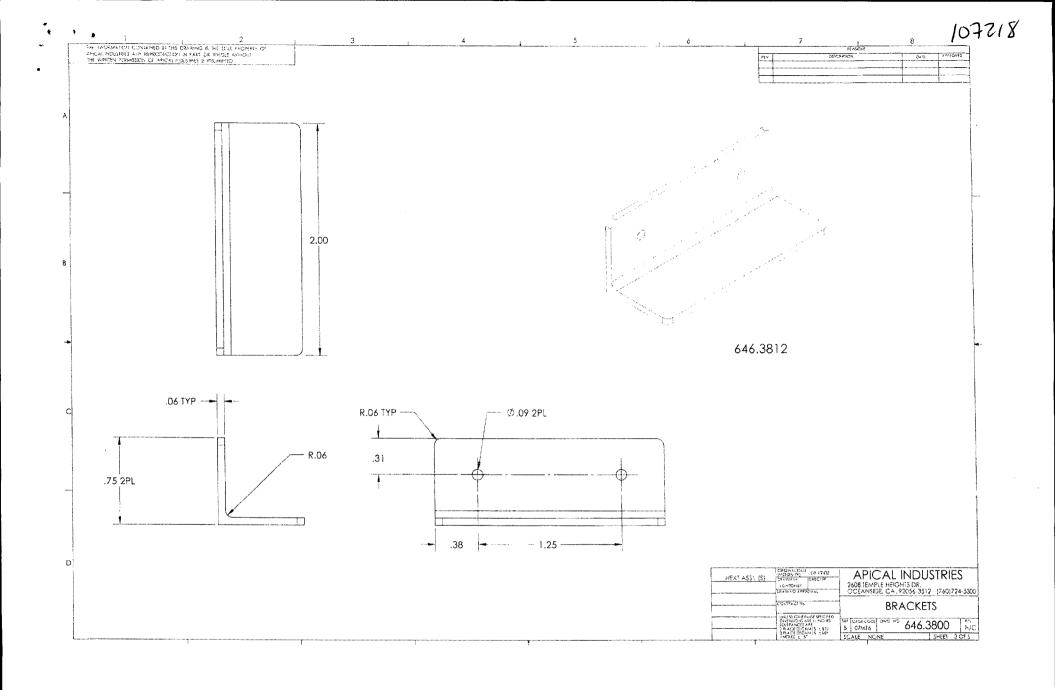
## SHEET 1, ZONE A2 IS:

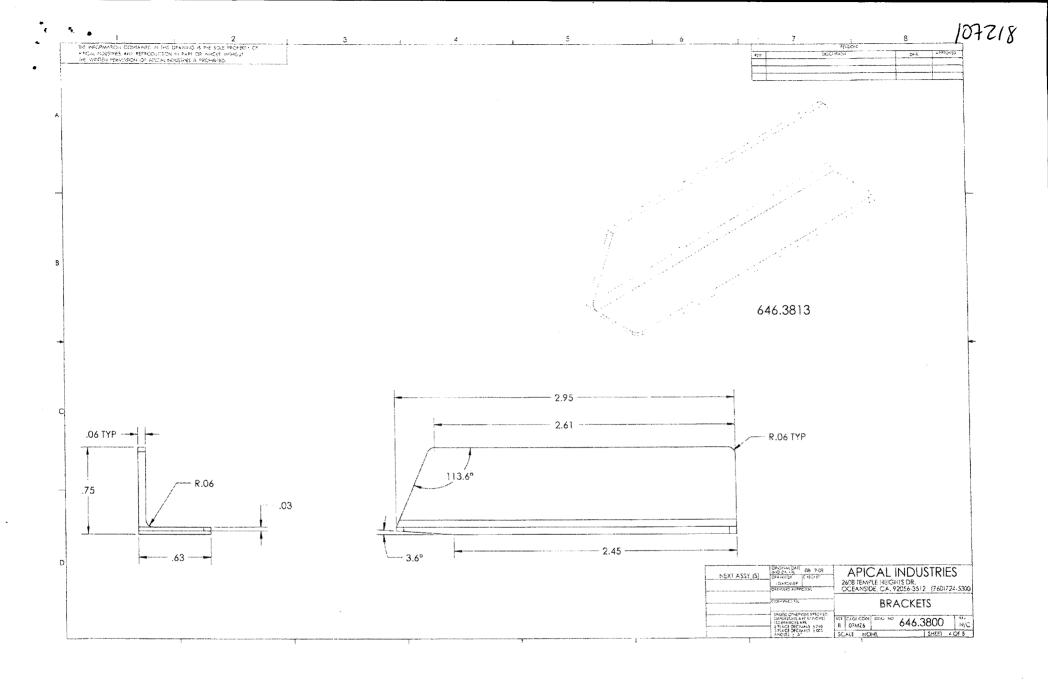
107218 MCJ 13-09-23

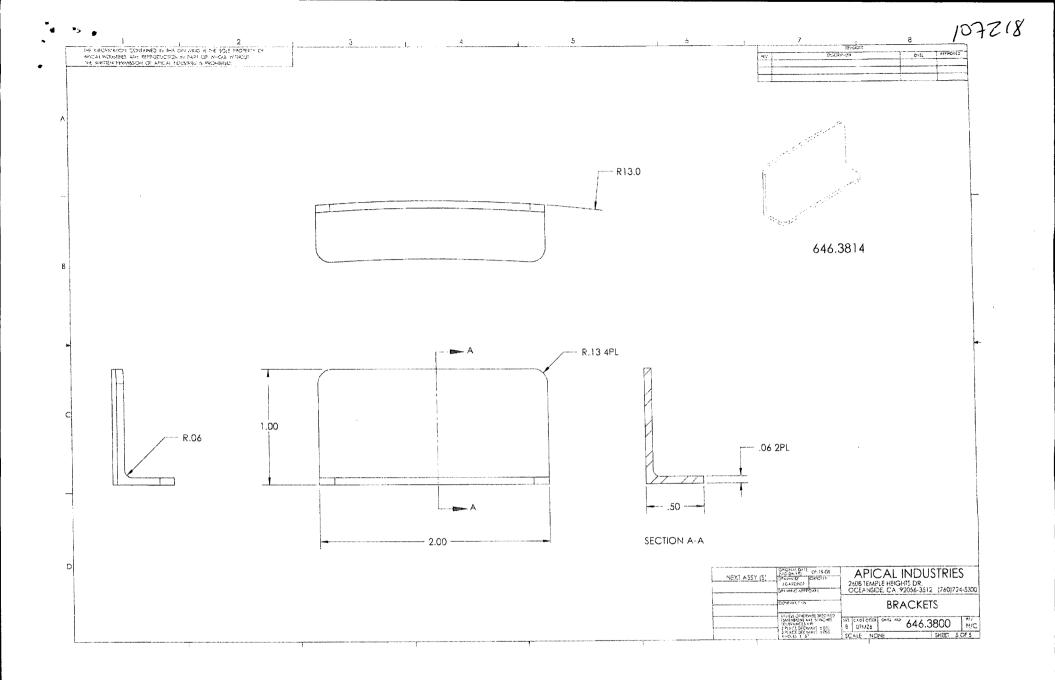
F/N TC PART NUMBER	Qly	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:	□ RFMS □	MDL   INSTALL INSTRUC		VIEW REQUIRED (ES 🖾 NO













A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

## Pack List

Number: 62694

Date: 21-Oct-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada **Ship To** 

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via					
Quantity	Description						
1	Part: ASST		Rev:				
lot							
	2 PCS 646.2910 (48.00) 4 PCS 646.3110 (10.65)						
	6 PCS 646.3811 (6.55)						
· ·	35 PCS 646.9910 (13.40) 32 PCS 647.2010 (11.90)						
	2 PCS D4821-1 (50.25)						
•	7 PCS D4823-1 (11.15) 2 PCS D4824-1 (13.40)						
	l						
	HARD ANODIZE BLACK						
	MIL-A-8625 TYPE III CLASS 2						
	PRIME MIL-P-23377J TYPE I CLASS N						
	PRICE IS PER PIECE						
	Job: 20130656	PO: 21510	Line:				
	Certificate of Conformance						
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.						
	ISO 9001 : 2008 REGISTERED						
	ATG SALES-2010 TERMS APPLY						
	DATE : 2/10/13						
	CERTIFIED SIGNATURE :						
	CERTIFIED SIGNATURE :						
	RECEIVER SIGNATURE :						
:		•					
		No.					
		in the second of					